

Work Order ID 56983

Tuesday, March 16, 2010 10:28:14 AM



Page 1

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (350 Basket)

10-322

Start Date: 3/16/2010

Start Qty: 200



Cust Item ID:

Required Date: 3/23/2010

Req'd Qty: 100



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-3-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R S.S. rod Batch: M109213 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

② PD 10.04.12.

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

Cpl 10.04.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56983

Tuesday, March 16, 2010 10:28:14 AM



Page 2

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 3/16/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/10/04/12

Memo

0.00

(2)

130



Packaging

Packaging

Identify as per dwg & Stock Location: basket

0.00

Memo

0.00

(2)

PD 10.04.12

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/12

10-4-12
(2)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, March 16, 2010 10:28:13 AM

Page 1

Work Order ID: 56983

Parent Item: D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 3/16/2010

Required Date: 3/23/2010

Comments: IPP revA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4021-9		Manufactured	No			100	Each	3.0000	2.0000			



Bushing

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

WA

3

56094

3

100

f

170.5455

1.8421



B 56945 PD 10.04.12

M304TS0.750W.049

Purchased

No



304 SQ Tube .75x.75x.049W

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

MAT

170.5455158

106604

2.4123

107460

28.2726

113763

139.860616

PD 10.03.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

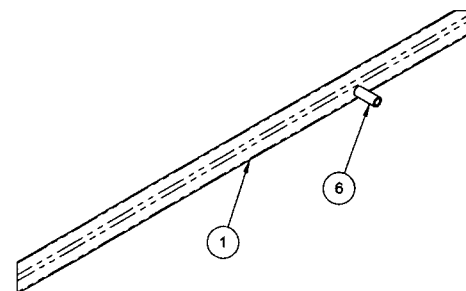
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

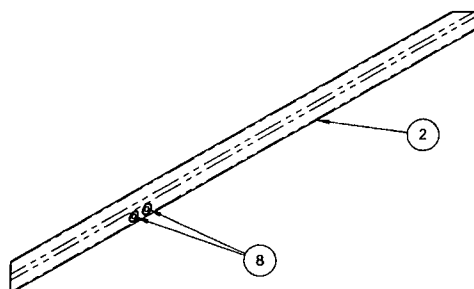
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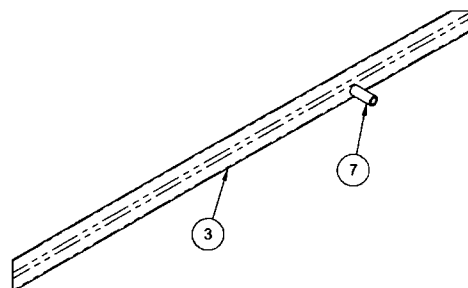
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X	X			D4035-041	LID RIB ASSY, FWD
			X		D4035-043	LID RIB ASSY, AFT
				X	D4035-045	LID RIB ASSY, FWD (LIGHT)
					D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



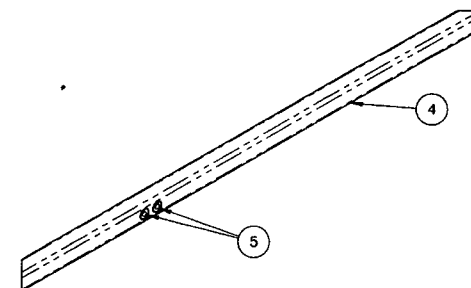
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

56983

RELEASED
2010-03-12

A		NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	JPH			SHEET 1 OF 5	
CHECKED		DRAWING NO.		TITLE	
MFG. APPR.		D4035		SCALE	
APPROVED		BASKET LID RIB ASSY		NTS	
DE APPR.		DATE 10.03.04			
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

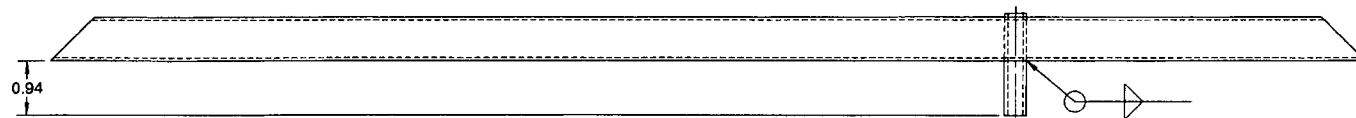
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD

C

C



D4035-3
RIB

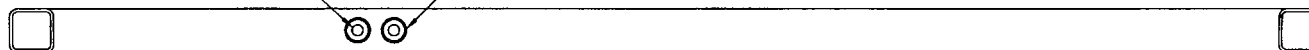
D4021-9
BUSHING
2 PL

G
G
TYP

D4035-043 BASKET LID RIB ASSY, AFT

B

B






RELEASED
2010-03-12
WD

304

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

56983

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

A

A

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8 7 6 5 4 3 2 1

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

D4035-11
BUSHING
2 PL

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
2010-03-12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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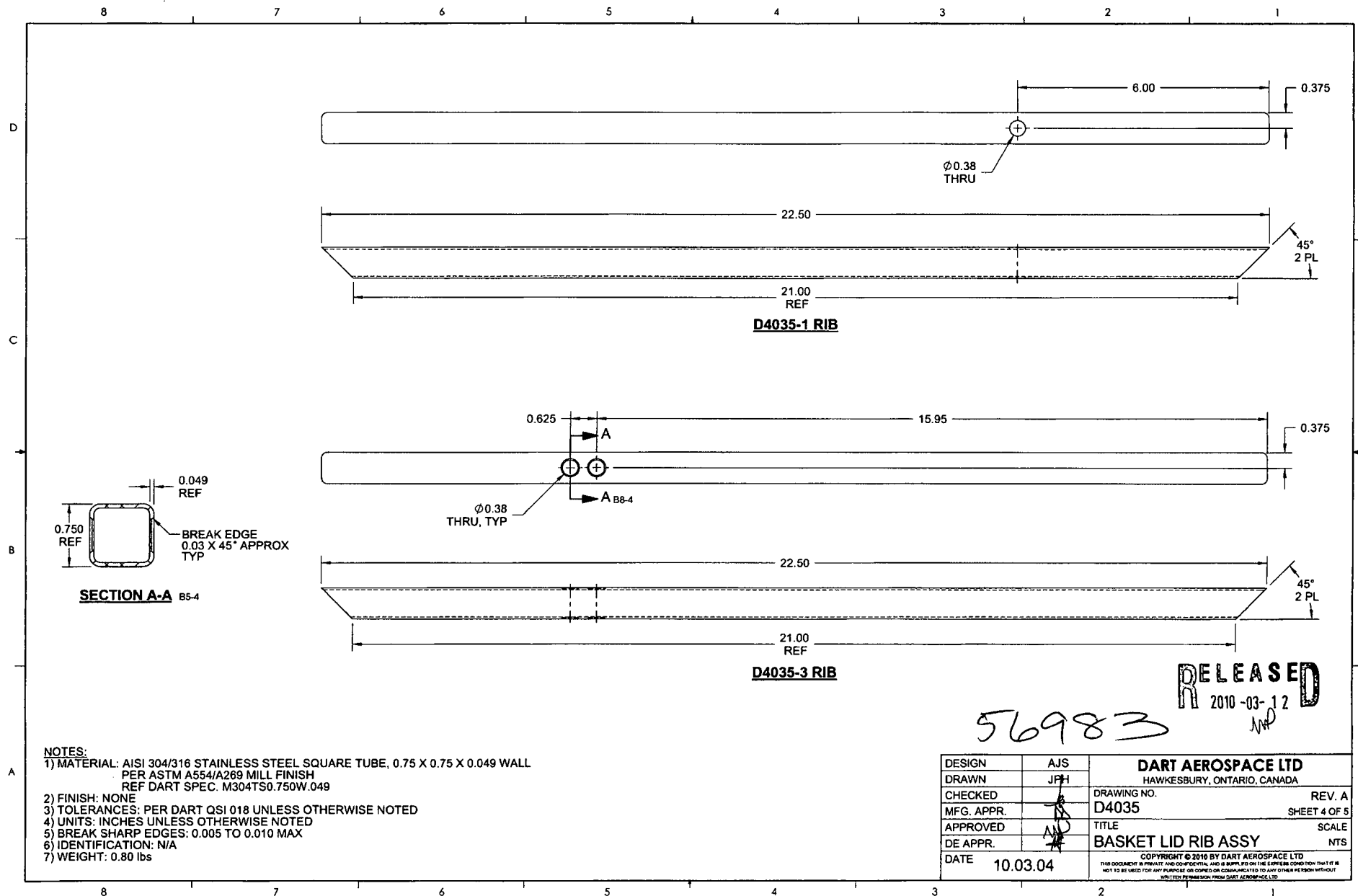
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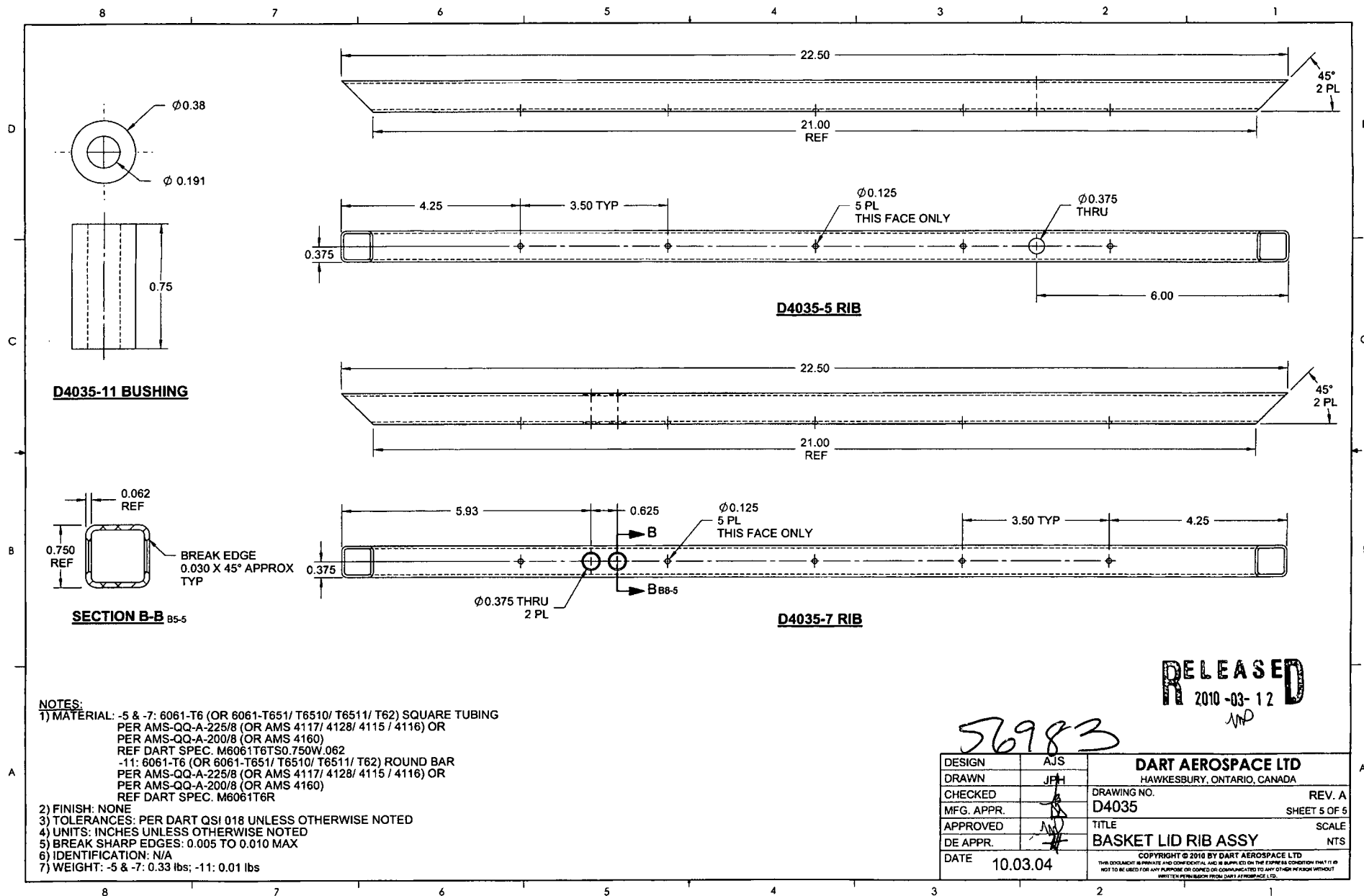
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